

Date: Thursday, 8/23/2007 11:52:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UNION
Job Number	: 34236		
Estimate Number	: 12630		
P.O. Number	: N/A	Part Number	: D2127251093
This Issue	: 8/23/2007 S.O. No. : N/A	Drawing Number	: D212-725-1 PG33 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: MA Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 34029	Material	: N/A
Written By	:	Due Date	: 9/3/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.08.23</u>		
Comment	: Est Rev: A New Issue 07-01-05 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303H1000	Inventory
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Comment: Qty.: 0.2625 f(s)/Unit Total : 1.0500 f(s)

303 1.00" HEX BAR ^{2g}

Batch: M-18453 M18419

07/05/25-26

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO Fa662 & DWG D212-725-1,

FOLIO REV: A

DWG REV: B

2-DEBURR AS REQUIRED

07/02/25-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/08/25-26

(B)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/08/26 (B)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/28 (B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 02/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UNION

Job Number: 34236

Part Number: D2127251093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6
A 07/08/28

Job Completion



u 07/08/28

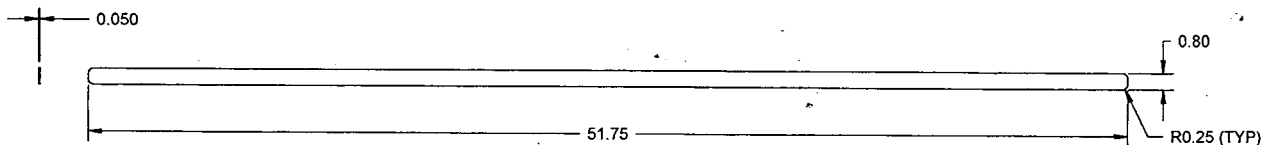
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

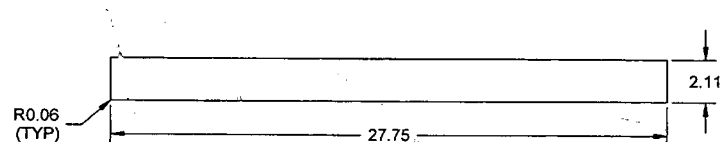
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

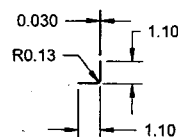
NOTE: Date & initial all entries



D212-725-1-089 STRAP



D212-725-1-091F FLAT PATTERN



D212-725-1-091 ANGLE
(MAKE FROM D212-725-1-091F FLAT PATTERN)

D212-725-1-089 NOTES:

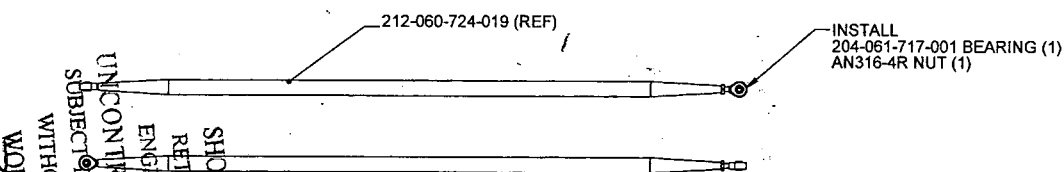
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.050 (18 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S18GA)

D212-725-1-091 NOTES:

2) MATERIAL: AISI 304/316 STAINLESS STEEL 0.030 (22 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S22GA)

GENERAL NOTES:

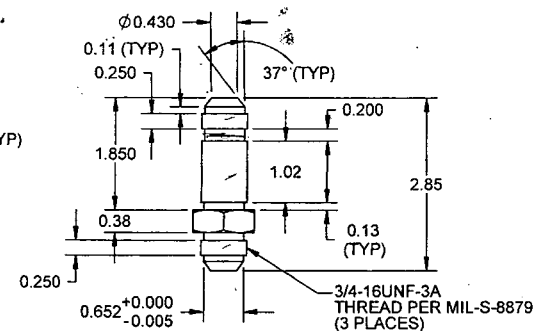
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



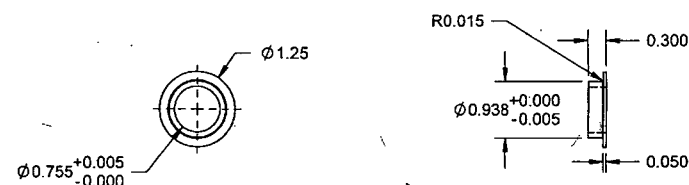
D212-725-1-919 ROD ASSEMBLY
(MADE FROM 212-060-724-019)

D212-725-1-919 NOTES:

- 1) MATERIAL: MADE FROM 212-060-724-019 TUBE ASSEMBLY
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D212-725-1-093 UNION
(SCALE 1:3)



D212-725-1-105 BUSHING
(SCALE 1:3)

D212-725-1-105 BUSHING:

1) MATERIAL: AISI 303/304/316 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R)

D212-725-1-093 UNION:

2) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR (REF. DART SPEC. M303H)

GENERAL NOTES:

- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	D212-725-1-919 WAS D212-725-1-921	
A	06.12.08	NEW ISSUE	
DESIGN	DC	DRAWN BY	RF
CHECKED	DS	APPROVED	<i>[Signature]</i>
DATE	07.05.11	TITLE	212S DETAIL PARTS
		DRAWING NO.	D212-725-1
		REV. B	SHEET 33 OF 44
		SCALE	1:6

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NO 34236
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 RETURN TO
 ENGINEERING
 SHOP COPY

DART AEROSPACE LTD		Work Order:	34236
Description: UNION		Part Number:	D212725 1093
Inspection Dwg:	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	± 0.030	.999				
$\phi 0.386$	± 0.010	.388				
R0.500	± 0.010	R.5				
0.074 x 30°	$\pm 0.010 / \pm 1/2^\circ$.074 x 30				
2.850	± 0.030	2.849				
1.850	± 0.010	1.850				
1.02	± 0.030	1.02				
0.250	± 0.010	.25				
0.250	± 0.010	.25				
0.200	± 0.010	.20				
0.13	± 0.030	.13				
0.38	± 0.030	.365				
0.11	± 0.030	.11				
$\phi 0.652$	$+0.000 / -0.005$.65				
$\phi 0.430$	$+ / -$.438				
37°	$\pm 1/2^\circ$	36.9				
3/4-16 UNF-3A						

Measured by: RD	Audited by: S.F.	Prototype Approval:
Date: 07/08/26	Date: 07/08/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

